

slip dty B

Work Order ID 58445

May 6, 2010 3:09:02 PM

Item ID: D206-555-007

Accept



Setup Start



Revision ID:

Stop



Item Name: Scuff Plate Aft LH

Start Date: 5/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-555

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Type Labels as per PPP D206-555-007

10-5-11
[Signature]

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Pull from stock:
D206-555-007 B37602 unformed

Form parts on hydraulic press as per Dwg. D206-555 using DT8320-7. Finish
form on bench forming Jig DT8321-7 Remove tooling tabs and deburr

10/05/11

16

Work Order ID 58445

May 6, 2010 3:09:02 PM

Page 2

Item ID: D206-555-007

Accept

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Item Name: Scuff Plate Aft LH

Start Date: 5/06/10 Start Qty: 4.00

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

150

Outsource process - Electrochemically polish

0.00



Outsource6

Memo

0.00

Outsource process - Electrochemical

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces. Issue P/O: _____ Possible supplier: TQF Technologies

160

Identify as per dwg & Stock Location: FP

0.00



Packaging

Memo

0.00

Packaging



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



5/6/11

(x16)

NA

[Signature]

(B. H. Beckett)

6/10/11 (16)

Work Order ID 58445

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Page 3

Item ID: D206-555-007

Accept



Setup Start



Revision ID:

Stop



Item Name: Scuff Plate Aft LH

Start Date: 5/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ME 10-5-11
1005-11

Picklist Print

May 6, 2010 3:09:01 PM

Page 1

Work Order ID: 58445



Parent Item: D206-555-007



Parent Item Name: Scuff Plate Aft LH

Start Date: 5/06/10

Required Date: 5/13/10

Comments: IPP: C 99.03.23 Returned to Electro Polish/ DM
IPP Rev:D Now on WaterJet 07-06-14 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D206-555-007		Manufactured	No				Each	16.0000				



Scuff Plate Aft LH

Location

Loc Qty

Loc Code

MEZZ

16

37602

16

WMC 10-5-11

DESIGN JB	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

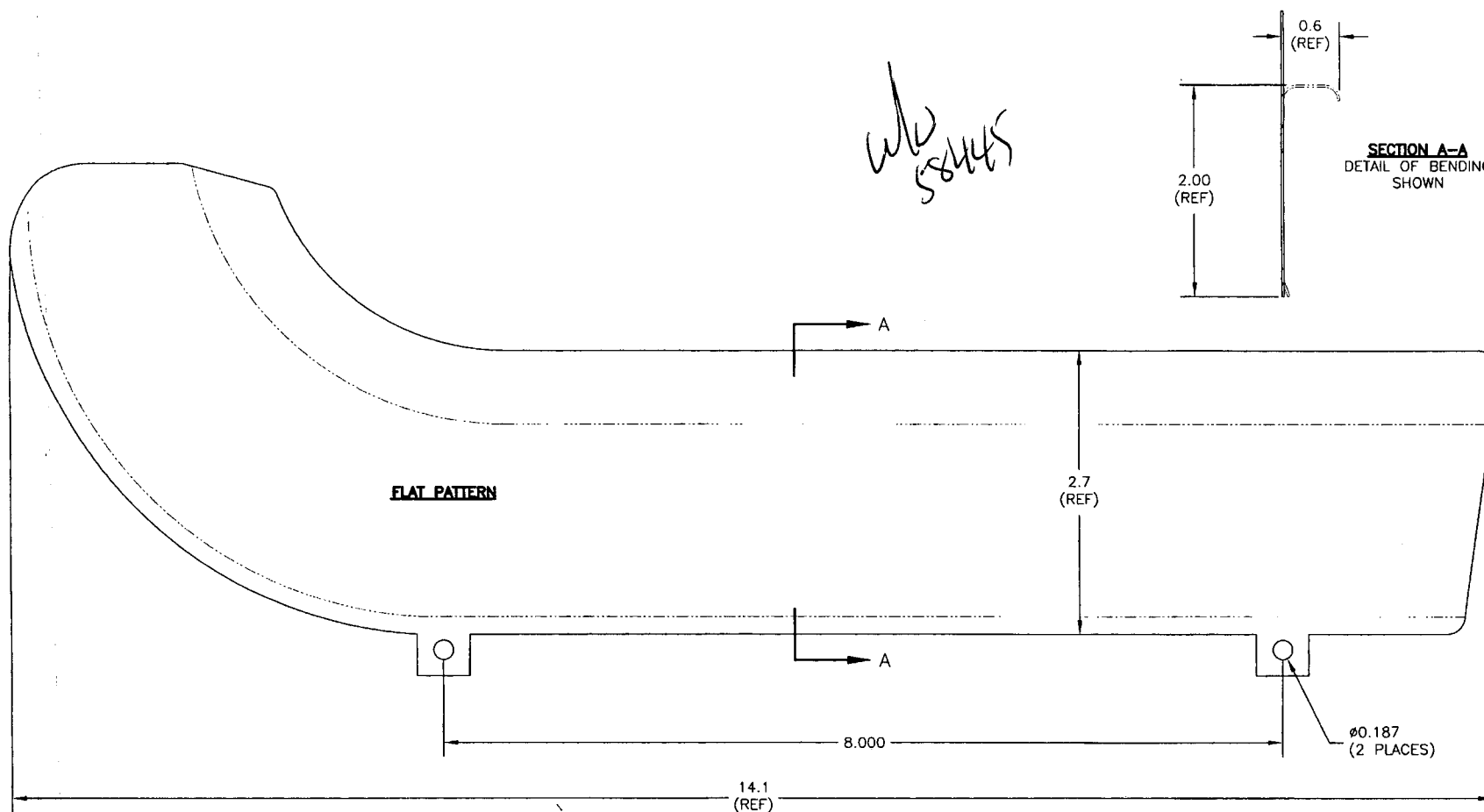
QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

RELEASED
67.11.08 *[Signature]*

5845
[Signature]

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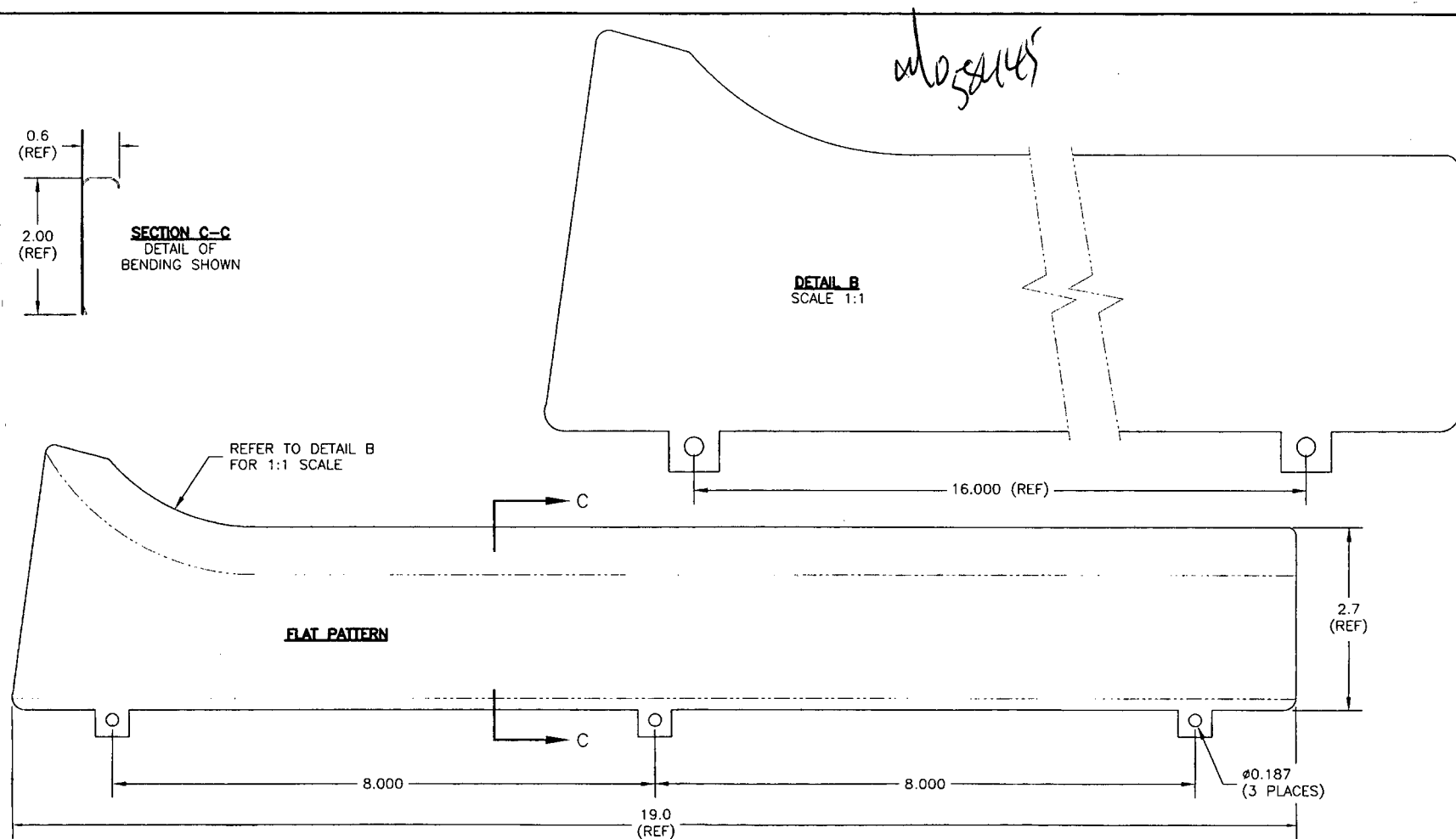
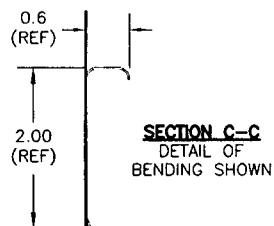
D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 07-11-88

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	

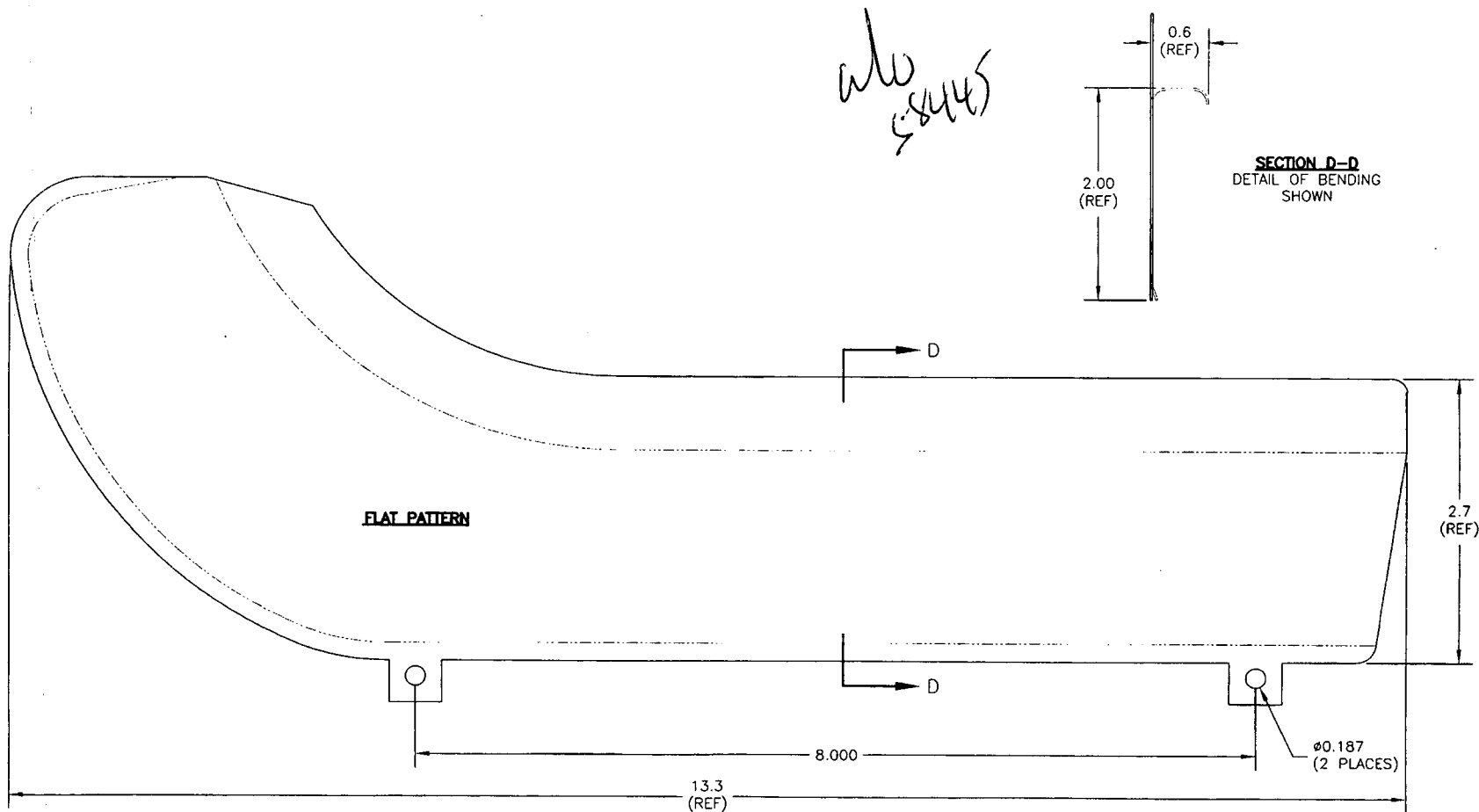


D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY B	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 3 OF 7 SCALE 2:3



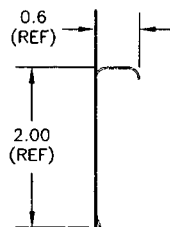
D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

NOTES

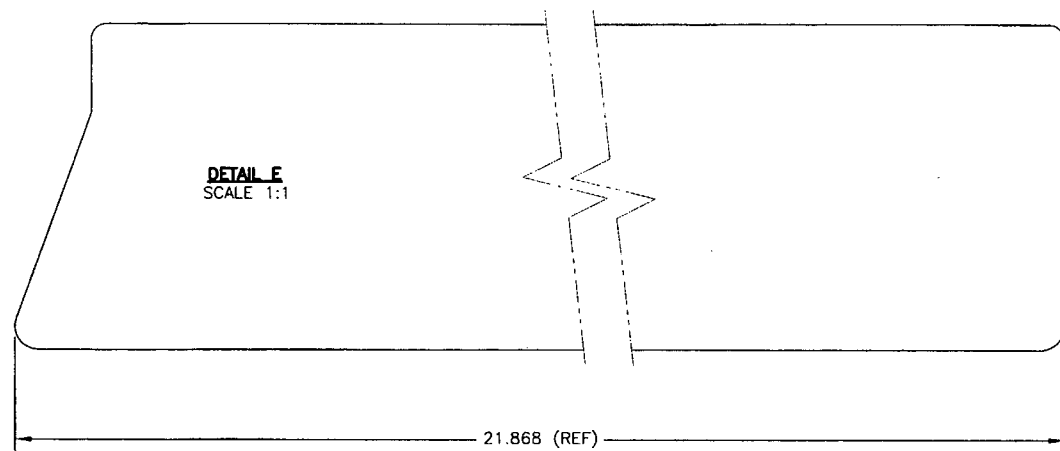
- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 4 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1

cto 58445

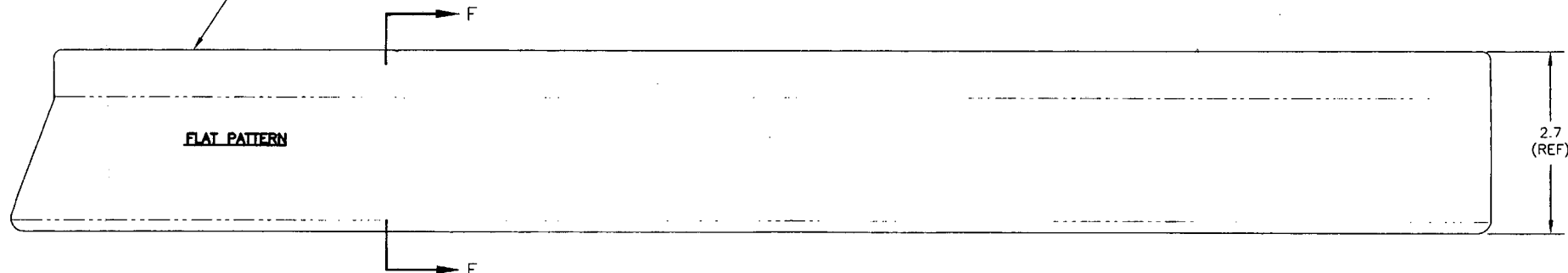


SECTION F-F
DETAIL OF
BENDING SHOWN



DETAIL E
SCALE 1:1

REFER TO DETAIL E
FOR 1:1 SCALE



FLAT PATTERN

2.7
(REF)

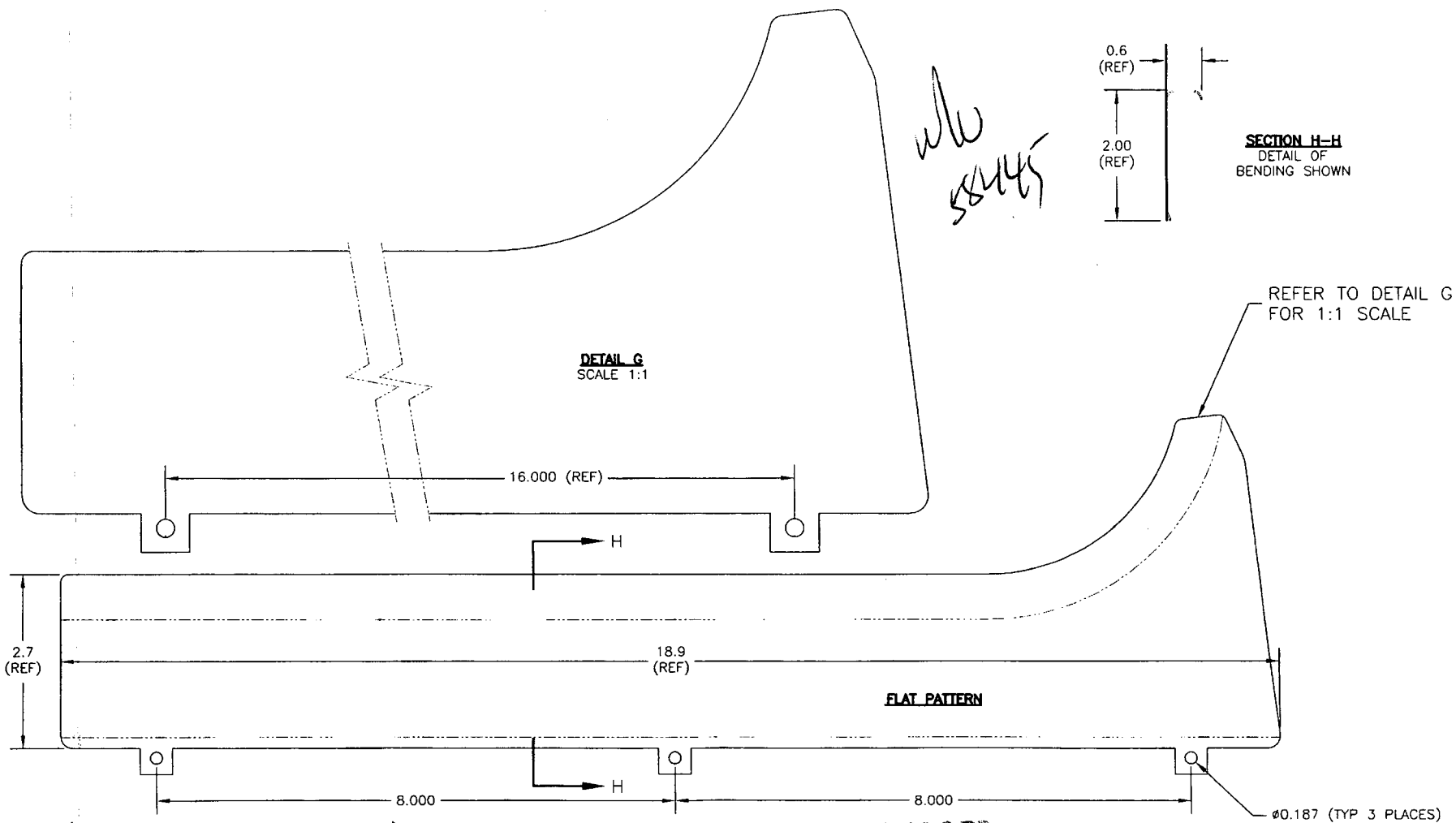
D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
6-11-02

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 5 OF 7 SCALE 2:3

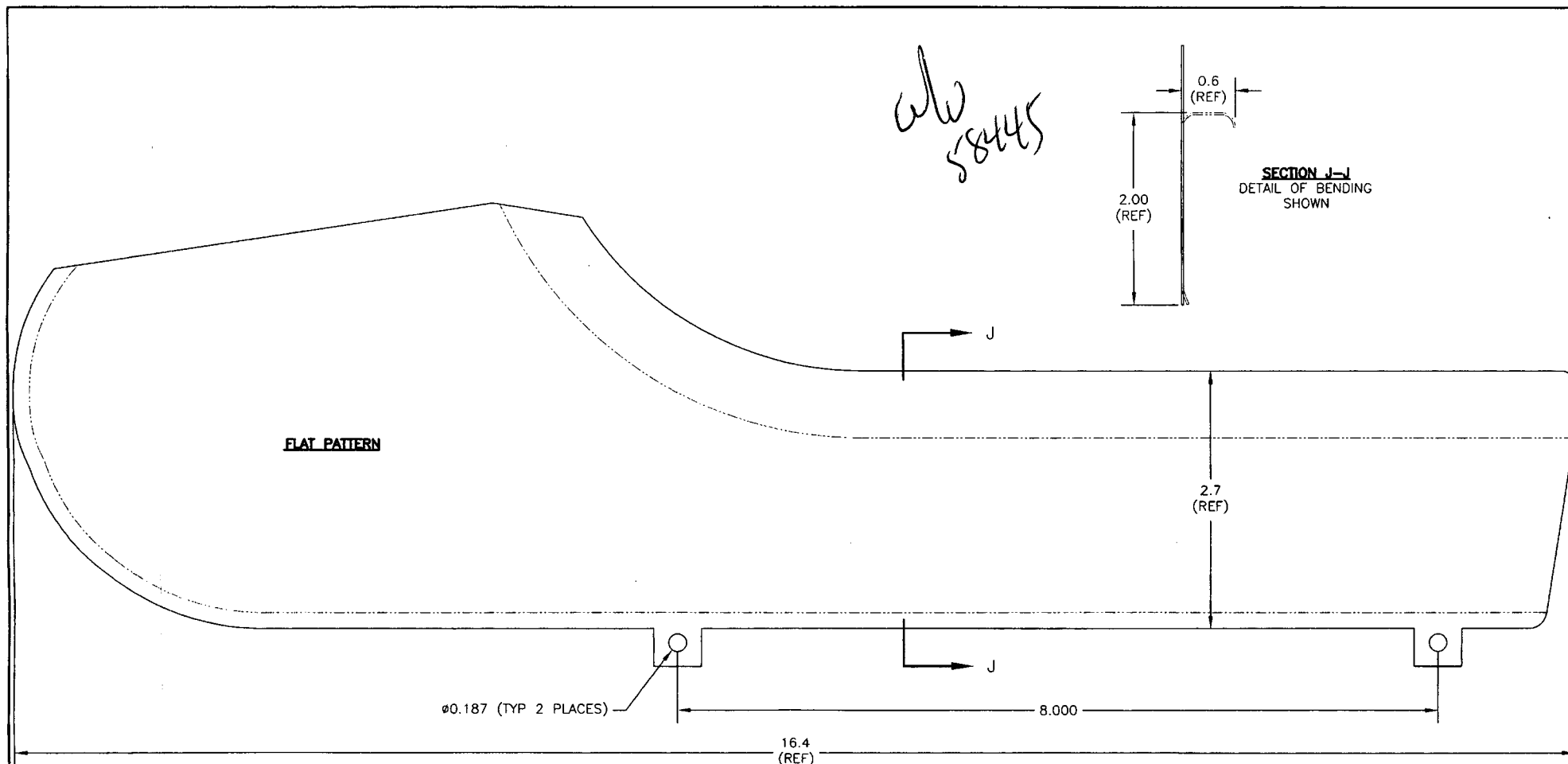


NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED JK	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
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- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
REL. 11.08.00

DESIGN JB	DRAWN BY <i>JB</i>	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1